

Work Order ID 78459

January-10-12 9:30:10 AM

78459

Page 1

Item ID: D206-642-312BL

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH

Start Date: 10/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 12/01/10 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

* SP

IIN-D206-642

N

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-312 CHG006

5

W 12 01 25 12
H J M L J 12-1-12

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

SP 12-01-12

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

W 12 01 25 12

B78447

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78459

78459

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January-10-12 9:30:10 AM

Item ID: D206-642-312BL Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube RH
 Start Date: 10/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-312								
	Location: _____								
	PPP Rev: <u> f </u>								
140									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

12/21/12

12/1/25

MLF 12-01-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-10-12 9:30:15 AM

Page 1

Work Order ID: 78459

78459

Parent Item: D206-642-312BL

*D206-642-312RI *

Parent Item Name: Skidtube RH

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: J 05.10.11 Added D3429-1 per CHG004KJ/CP/JLM/EC
 IPP Rev: K 07-12-04 ECN 1080p DD verified by: ec
 IPP Rev: L 08-09-29 as per DSI9421 DD verified by: EC IPP
 Rev: M 09-03-02 as per DSI9440 rev.a verified by: EC
 IPP Rev: N 09-03-03 as per DSI9421 rev.b verified by: EC IPP Rev: O
 as per REV.N DD 10.04.19 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-341		Manufactured	No			110	Each	3.0000	1	1			
D206-642-341									**	78459			
Replacement Skidtube													

Location	Loc Qty	Loc Code
FG081	1	
57156	0	
57160	0	
57161	0	
69950	1	
FG082	2	
36550	1	
69952	1	

D206-648-013

CHOW

Manufactured No

110

Each

7.0000

1

1

D206-648-013

GHW Modification

**

Location	Loc Qty	Loc Code
FG125	7	
71578	2	
75825	5	

ATTN: D3414-041 BLUE

SP

12-01-16

1x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-10-12 9:30:15 AM

Page 2

Work Order ID: 78459

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

78459

***D206-642-312RI ***

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2932-2

Manufactured No

110

Each

11.0000

1

1

**

D2932-2

Saddle RH Out, 206

SP

Location

Loc Qty

Loc Code

ST428

11

72515

1

74602

6

75100

4

IX

BLUE

D2933-2

Manufactured No

110

Each

2.0000

1

1

**

D2933-2

Saddle RH In, 206

SP

Location

Loc Qty

Loc Code

ST421

1

72883

1

ST428

1

71063

1

IX

BLUE

D2938-2

Manufactured No

110

Each

1.0000

1

1

**

D2938-2

Saddle RH Out, 206

SP-01-16

Location

Loc Qty

Loc Code

ST428A

1

71059

1

IX

BLUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

January-10-12 9:30:15 AM

Work Order ID: 78459

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

78459

***D206-642-312RI ***

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2939-2

Manufactured No

110

Each

1.0000

1

D2939-2

Saddle RH In, 206

**

B71057

Location

Loc Qty

Loc Code

ST428A

1

71057

1

BLUE

AN3-41A

AN3-41A

Bolt

Purchased No

110

Each

959.0000

8

**

m 119042

Location

Loc Qty

Loc Code

ST354

959

119042

959

D2652

Manufactured No

110

Each

991.0000

16

16

D2652

Bushing

**

12-01-13

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

947

73834

15

73836

36

76132

96

76133

400

77135

400

hex

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

January-10-12 9:30:15 AM

Work Order ID: 78459

78459

Parent Item: D206-642-312BL

***D206-642-312BL ***

Parent Item Name: Skidtube RH

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

6,089.000

8

8

MS21042L3

Nut

**

SP

Location

Loc Qty

Loc Code

ST300

6089

117441

16

117885

32

118451

5

118927

3

119017

5559

119075

474

8x

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

8

8

AN960JD10

Washer

**

11/20/12 SP

AN5-10A

Purchased

No

110

Each

634.0000

4

4

AN5-10A

Bolt

**

SP

Location

Loc Qty

Loc Code

ST337

634

118191

80

119547

454

119981

100

4x

AN5-11A

Purchased

No

110

Each

1,251.000

4

4

AN5-11A

Bolt

**

SP 12-01-13

Location

Loc Qty

Loc Code

ST337

1251

118191

13

119512

1238

4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January-10-12 9:30:15 AM

Work Order ID: 78459

78459

Parent Item: D206-642-312BL

*D206-642-312RI *

Parent Item Name: Skidtube RH

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN960JD516 NAS1149D0563J Purchased No

110 Each

0.0000

8 8

AN960.ID516

Washer

**

mil8206 SP.

AN4-6A Purchased No

110 Each

3,572.000

12 12

AN4-6A

Bolt

**

SP.

Location

Loc Qty

Loc Code

ST356

3572

119017

3572

AN960JD416 NAS1149D0463J Purchased No

110 Each

0.0000

24 24

AN960.ID416

Washer

**

mil19075 SP.

MS21042L4 Purchased No

110 Each

7,915.000

12 12

MS21042I 4

Nut

**

SP12-01-13.

Location

Loc Qty

Loc Code

ST300

7915

117441

51

117601

342

118451

133

119017

2389

119075

5000

12x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January-10-12 9:30:15 AM

Work Order ID: 78459

78459

Parent Item: D206-642-312BL

***D206-642-312BL ***

Parent Item Name: Skidtube RH

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110 Each

20.0000 : 1 1

D3407-043

Tow Ring

**

SP

Location

Loc Qty

Loc Code

ST463

18

68339

2

74519

16

ST464

2

68339

0

71040

1

72513

1

BLUE

D3456-1

D3456-1

Washer

Manufactured No

110 Each

79.0000 : 1 1

**

SP 12-03-13

Location

Loc Qty

Loc Code

FG

7

25701

7

ST034

50

77486

50

ST044

22

66848

3

71165

2

73493

17

1x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January-10-12 9:30:15 AM

Work Order ID: 78459

78459

Parent Item: D206-642-312BL

***D206-642-312BL ***

Parent Item Name: Skidtube RH

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3457-1

Manufactured No

110

Each

44.0000

2

2

D3457-1

Washer

**

B78231 IX.

Location

Loc Qty

Loc Code

FG

10

32409

10

ST044

34

67779

1

71849

3

76231

30

IX

MS21043-4

Purchased No

110

Each

1,058.000

1

1

MS21043-4

Nut

**

SP

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

470

118686

470

ST301

548

119309

52

119546

496

/

AN4C5A

Purchased No

110

Each

399.0000

1

1

AN4C5A

BOLT

**

SP. 12-01-13.

Location

Loc Qty

Loc Code

FP002

19

112243

19

ST355

380

112243

280

119017

100

IX

January-10-12 9:30:15 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January-10-12 9:30:15 AM

Work Order ID: 78459

78459

Parent Item: D206-642-312BL

*D206-642-312RI *

Parent Item Name: Skidtube RH

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C416 NAS1149C0463 Purchased No

110 Each 0.0000 1 1

*S** *AN960C416*

washer

** * mil 7735 SP.

D3413-1

Manufactured No

110 Each 59.0000 1 1

*S** *D3413-1*

Ring

** * SP. B72533 1x

Location

Loc Qty

Loc Code

ST420

2

66387

1

70773

1

ST464

55

73822

3

75478

52

ST473

2

71041

2

66387

BLUE

D2712

Manufactured No

110 Each 1,642.000 10 10

*S** *D2712*

Set Screw

** * SP 12-01-12.

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

1592

76065

1592

10x.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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January-10-12 9:30:15 AM

Work Order ID: 78459

78459

Parent Item: D206-642-312BL

***D206-642-312BI ***

Parent Item Name: Skidtube RH

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2934

Manufactured No

110

Each

60.0000

2

2

D2934

Saddle Spacer

**

Sp

Location

Loc Qty

Loc Code

FG

6

31929

6

ST021

54

74501

19

74883

35

2x

D2935

Manufactured No

110

Each

56.0000

2

2

D2935

Saddle Spacer

**

Sp 12-01-12

Location

Loc Qty

Loc Code

FG

6

31793

6

ST021

50

74503

20

74882

30

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -347	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-347	WEARSHOE KIT (REPLACES -343)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	* WASHER (OR AN960JD10)
13	4	4	4	4						*AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	* WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D3535-11	WEARSHOE (REPLACES D2656-11)
22B					1	1				D3536-11	GASKET
23A					1	1				D3535-23	WEARSHOE (REPLACES D2656-23)
23B					1	1				D3536-23	GASKET
24A					1	1				D3535-35	WEARSHOE (REPLACES D2656-35)
24B					1	1				D3536-35	GASKET
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1	1	1						D3456-1	WASHER
32	1	1	1	1						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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Revision: 0

Date: 11.06.15

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -347	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
50							1	1		D4364-041	FWD WEARPLATE ASSY
51							1	1		D4364-043	AFT WEARPLATE ASSY
52							18	18		D3873-1	BUSHING
53							4			D2649	SPACER
54A							9	9		AN3-36A	BOLT
54B							9	9		NAS1149C0332R	WASHER (OR AN960C10L)
54C							9	9		MS21042-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D2650-5 OR D4361-041 ASSEMBLY ABOVE

(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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